

Date: Monday, 11/12/2007 11:46:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 35631	
Estimate Number : 11041	
P.O. Number : N/A	Part Number : D2809
This Issue : 11/12/2007 S.O. No. : N/A	Drawing Number : D2809 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A1
Previous Run : 34035	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 11/30/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>50.52</u> Um: Each
Comment : Est C 02.03.07 Now turned in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.1045 f(s)/Unit Total : 4.1790 f(s)
 6061-T6 Round Bar .500"
 Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: M105671 20 07/11/19

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Machine as per Folio FA204

20 07/11/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 07/11/19 (52)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 07/11/19

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble & deburr all sharp edges as per dwg

20 07/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ND Date: 07/11/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

07-11-20

X52

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

M105914

BR 07-11-20

(02)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5748

PC 7/11/22

(52)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1702/11/22

Job Completion



U 07-11-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

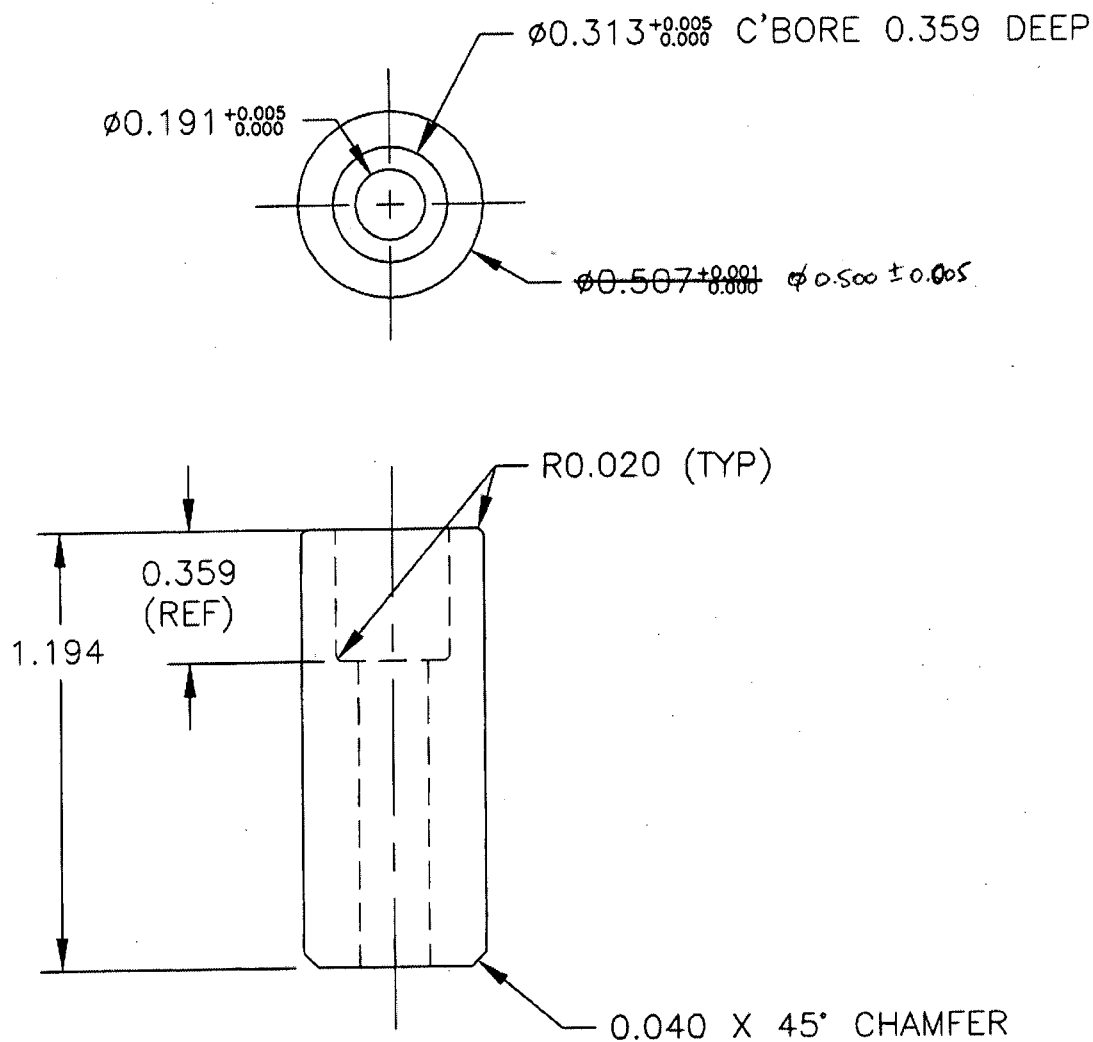
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>CP</i> 01.04.26	ADD POWDER COAT; $\phi 0.500$ UNLS $\phi 0.507$	

RELEASED
00.11.13 *[Signature]*



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35631

PER DART QSI 005 4.3

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